

Work Order ID 77350

Tuesday, December 06, 2011 9:58:55 AM

77350

Page 1

Item ID: D4327-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Angle

Stop ***NS2***

Start Date: 12/6/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/8/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MKDate: 11-12-06

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4327

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

2021.040

1-Cut as per Dwg

Dwg Rev: 1Prog Rev: 1

2-Deburr if necessary

11-12-6

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

11-12-6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

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Work Order ID 77350

Tuesday, December 06, 2011 9:58:55 AM

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Page 4

Item ID: D4327-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Angle
Start Date: 12/6/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/8/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/12/12 7
(3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, December 06, 2011 9:58:55 AM

Page 1

Work Order ID: 77350

Parent Item: D4327-1

Parent Item Name: Angle

Start Date: 12/6/2011

Required Date: 12/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No				sf	69.8184		0.4926316			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MAT022			69.818421						
				117684			69.818421						

1311-12-4

117684

3

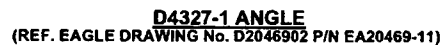
Dart Aerospace Ltd

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1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/A OR AMS-QQ-A-250/A
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED





4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.17 lbs

8) SHRINKING AREA TO SUIT DT9753 TEMPLATE

A	NEW ISSUE		RF	10.11.22
REV.		DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4327 TITLE VRD PARTS		
DRAWN	RF			
CHECKED				REV. 1 OF 1
MFG. APPR.				SHEET 1 OF 1
APPROVED				SCALE
DE APPR.				NT
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN AND SIGNED AUTHORIZATION OF DART AEROSPACE LTD.		

Dart Aerospace Ltd

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D4327-3 ANGLE
(MAKE FROM D4327-3F FLAT PATTERN)
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-7)

D4327-3F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-7)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs
- 8) FORM TO SUIT DOOR PROFILE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4327	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

#77350

RELEASED
2011-04-06

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